Work Order Doctober-29-13 9:52				*	1087	727*					:	Page 1
Item ID: D3: Revision ID: Item Name: Gus	204-13	: <u>-, : : : : : : : : : : : : : : : : : </u>	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	Accept	•	*N900	0040	100)* s	etup Star Stop	1 🔃	S1* S2*
Start Date: 11/ Required Date: 11/ Reference:		Qty: 8.00 i Qty: 8.00	*8* *8* }	414*		Cust Item Customer:						
Approvals: Pr	ocess Plan: _/	ルブ	Date: 13-11-01	Tooling	•	D	ate:	- · · · · · · · · · · · · · · · · · · ·	R	tun Star	1/1	R1*
Q	C:		Date:	SPC (Y	/N): _	D	ate:			Stop	` *N	R2*
Sequence ID/ Work Center ID	Opera Descr			Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision N	br										
D3204	Rev A1	i										
100:	FLOW	WATER JET		0.00					1			1
100 Waterjet		Memo		0.00					19			13,12.10
FLOW CNC Waterjet			Dwg D3204 Dwg Rev:_cessary		g Rev: 🔼	_ 2-						13,12.10
110	QC2- I	nspect parts off m	achine FAI/FAIB	0.00								•
110 QC Quality Control		Memo		0.00					14	0	· · · · · · · · · · · · · · · · · · ·	Ac 13.12.1
120 *120*	QC Ś - I	nspect parts - seco	ond check	0.00	DAS 27 9-89				14			
QC Quality Control		Memo		0.00	13/12/1	, D			_1_1			

										DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE			
Part No						Rework Scrap Use-as-is Work Order Update Rework Skid-tube Machining Small Fab Thermoforming Finishing Large Fab Composite			Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1				Descri	tion of work order update	Initial	T Ac	tion	Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Chief En	ł .	cription	Date	Verification	QC Inspector
Doc/Data			,									
Equip/Tooling												
Operator			:									
Material							1					
Setup												
Other												
Process												
Supplier			,									
Training												
Unapproved								<u>l</u>				
		<u> </u>				F	AULT CAT	EGORY				
Landi	ng G	ear				General	_			7		-
	_	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
	LJ'	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardv	are		Over/Under	tolerance	Temperature/Cure
	\vdash	Cracks				Broken/Damaged		tion Incomplete		Part Incorre	—	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	\vdash	ctions Incomplete	'Unclear	Part Lost/M	_	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	\vdash	tenance	<u> </u>	Part Moved		
	Heat Treat			<u> </u>	Countersink	Mislal			Positioned \		7	
	Н	Inspection		Tube		Cut Too Short	Misre		<u> </u>	Power Loss/	/Surge	Other
	1	Ripples in	Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord October-29-13				*108	R727*							Page
Item ID: Revision ID: Item Name:	D3204-13 Gusset	, 		Accept	*N900	040	100)* s	Setup	Start Stop	I VI	S1* S2*
Start Date: Required Date Reference:	11/22/13 : 11/22/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:		R		Start Stop		R1* R2*
Sequence ID/ Work Center I 130' *130' Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location:_ WA C	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty DA		Reject Number	Insp. Stamp

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

Quality Control

Af / Rm 13/12/11 MLS 13-12-11

											DQA:	Da	te:	
NCR:	es .	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPDATE					
											QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION			AGAII	NST DE	PARTMENT	PROCESS		
Part I	– No					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Crossto Machining Small noforming Finish Large Fab Compo	Fab ning		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
NCKI	' '					Work Order opdate	1		compo	site[!	Supplier	Ш	لــا
Root					Descri	ption of work order update	П	nitial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling	Ш												1	
Operator														
Material	Ш		,											
Setup	Ш						İ							
Other	Ц													
Process	Ш						l							
Supplier	Щ													
Training	Ш													
Unapproved														
							AUL	T CATE	GORY					
Landi					_	General	_	7		_	7			ı
		Bending			-	Bend	\perp	Grain		_	Ovalized		-	Pressure/Forced
	-	Centre No	ot Concei	ntric to	o/s	BOM/Route	\perp	Hardwa			Over/Under		_	Temperature/Cure
	-	Cracks			<u> </u>	Broken/Damaged	\perp	1	on Incomplete		Part Incorred		\vdash	Weld
	Щ	Crushed/0	Crimped			Burrs	\perp	Instruct	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing		Wrong Stock Pulled
	1 6	Cuffs				Contamination	1	Mainte	nance	I	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Heat Treat

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Picklist Print

October-29-13 9:52:20 AM

Page 1

Work Order ID:

108727

Parent Item:

D3204-13

Parent Item Name:

Gusset

Start Date: 11/22/13

Required Date: 11/22/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: C05.08.11Added Step 25 KJ/JLM

Comments.	111. 605.00.117	adod Stop 25 IX	3/3/2141										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	155.0000	0.0057	0.048	Az	13.1	2.10

Location	Loc Otv	Loc Code	
MAT021	155		
m127272	155		127272

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE			
											QA Closed	: Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	ا. No					Rework Scrap Use-as-is		Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet od. Eng. Coor.	Engineering Quality Other
NCR I	NO.		······································	· · · · · · · · · · · · · · · · · · ·	 	Work Order Update	ן נ		Large Fab	Composite	j	Supplier	
Root		Date	Ston	Otv		ption of work order update	1	nitial		tion	Sign &	Verification	OC Inspector
Cause	г	Date	Step	Qty		or Non-comormance	Cit	ief Eng	Desc	ription	Date	verification	QC Inspector
Doc/Data	Н												
Equip/Tooling	Н						l						ĺ
Operator	\vdash								:				
Material	\vdash												
Setup													
Other	\vdash						1				1		
Process	Н												
Supplier	_						1						
Training 	\vdash		ļ t										
Unapproved			İ	<u> </u>				T CATE	CORY		<u> </u>		
Landi	nø (iear				General	AUL	.I CAIL	GONT		 		
	٦	Bending			[Bend	Г	Grain			Ovalized		Pressure/Forced
		Centre N	ot Concer	ntric to (BOM/Route	<u> </u>	Hardwa	re	—	Over/Under	r tolerance	Temperature/Cure
	\vdash	Cracks	or contect	10100	٠,¸ –	Broken/Damaged	\vdash	1	on incomplete	—	Part Incorre		Weld
	\vdash	Crushed/	Crimped			Burrs		d	ions Incomplete/	Unclear —	Part Lost/M		Wrong Stock Pulled
	-	Cuffs	Cimped		<u> </u>	Contamination		Mainte	•	Official	Part Moved	_	Tantonia prock Lanea
		Heat Trea	at		\vdash	Countersink	\vdash	Mislabe		 -	Positioned		
	\vdash	}		Tube	<u> </u>	╡	\vdash	-		<u> </u>	4	_	Other
		Inspectio		Tube		Cut Too Short		Misread			Power Loss,	_	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	108727
Description: Gusset	Part Number:	D3204-13
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

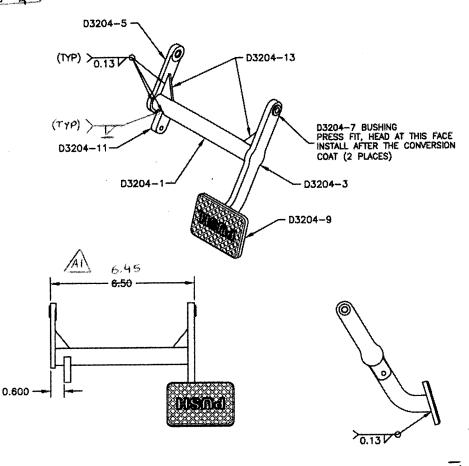
	FiR	ST ARTICLE II	NSPECTI	ON CHE	CKLIST	
		X First Arti	cle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	.98	-		V	JKm 05
0.75	+/-0.030	,73			V	
0.125	+/-0.010	.120			V	
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			DAS	\$		
easured by:	De	Audited by:			Prototype	Approval: N/A
Date:	13.12.10	Date:	13/12	(/()		Date: N/A
ev Date	Change					Revised by Approv

H:\FÖRMS\Quality Assurance\approved QA\FAI revD	





	DESIGN	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
	CHECK	EO,	APPROVED	DRAWING NO.	REV. A						
'		4	-	D3204	SHEET 1 OF 3						
	DATE	-1-4		TITLE	SCALE						
	04.0	1.27	·	RELEASE PEDAL ASSEMBLY	NTS						
	Α		04.01.27	NEW ISSUE	,à						
	A۱	## H	05.07.15	6.45 WAS 6.50							



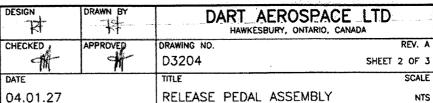
D3204-041 RELEASE PEDAL ASSEMBLY

1) BREAK ALL SHARP EDGES 0.005 TO 0.015

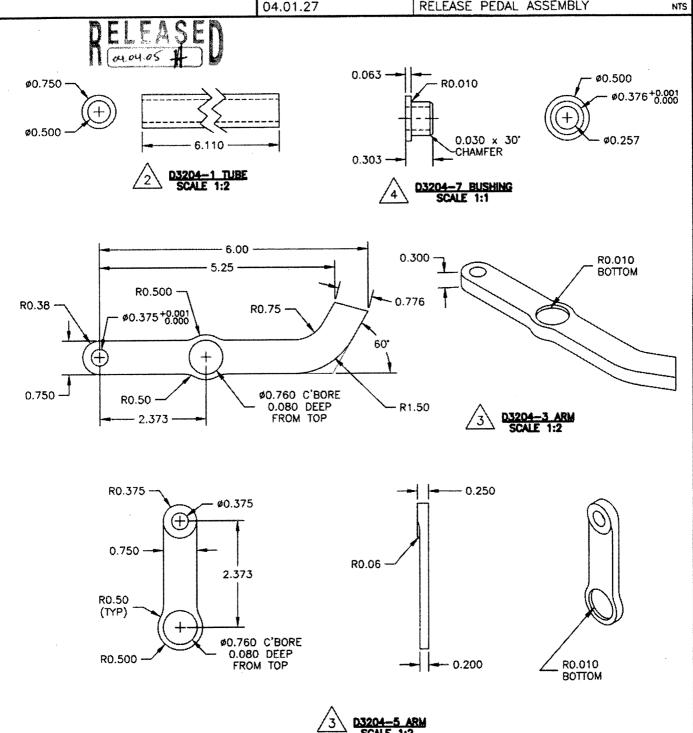
2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)

3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BI
4) MATERIAL: AISI 303 SS (M303R)
5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
7) WELD ASSEMBLY PER QSI 004
8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
11) ALL DIMENSIONS ARE INCHES



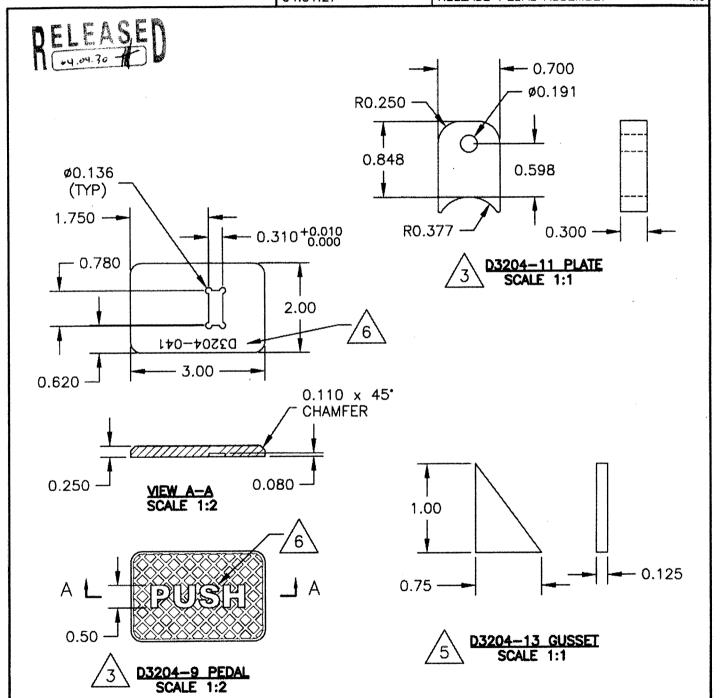


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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE		THE THE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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